

Date: Thursday, 3/13/2008 10:20:24 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 37930	
Estimate Number : 10383	
P.O. Number :	Part Number : D30661
This Issue : 3/13/2008 S.O. No. :	Drawing Number : D3066 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 37878	Material :
Written By :	Due Date : 3/25/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JD 080313</u>	
Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF	
Est Rev:B Now M6061-T6 06-06-23 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0992 sf(s)/Unit Total : 3.9690 sf(s)

Material: 6061-T6 0.080" thick

(M6061T6S.080)

Batch: 107276X  $21 = 2.1$

$104921 \times 6 = .6$

106320X  $14 = 1.6$

IB 8-3-24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3066

Dwg Rev: B

Prog Rev: B

IB 8-3-24

2-Deburr if necessary

IB 8-3-24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

0803-24 (43) counted

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

IB 08-03-25

(43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER

Job Number: 37930

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

8/3/26 SLP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 237

8/3/26

SLP

(43x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(43)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



mf

08-03-27

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

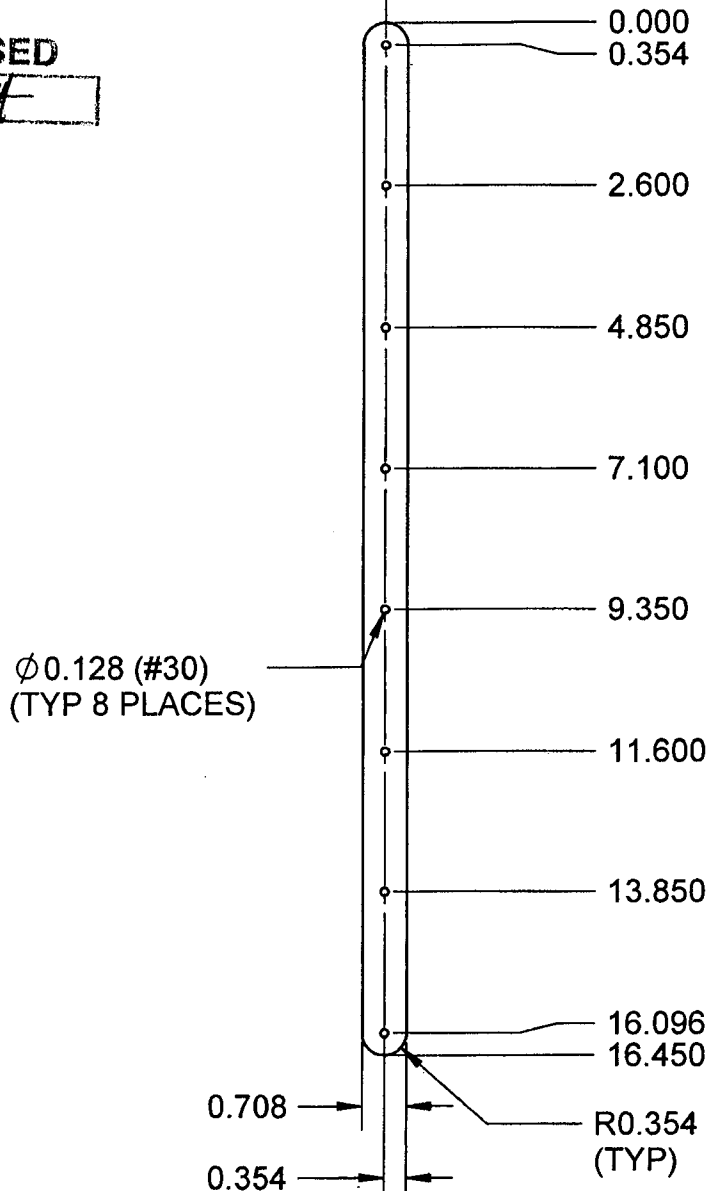




DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3066</b>	REV. B SHEET 1 OF 1
DATE <b>06.05.29</b>		TITLE <b>SPACER</b>	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**

*06.06.20* *[Signature]*



**D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK COPY  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK  
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
FOR TOOLS & EQUIPMENT  
WITHOUT NOTICE  
NO. **37930**

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